Work Order ID 93161-

November-15-12 8:56:55 AM

93161

Page 1

November-15-12	2 8:30:33 AI	M								
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	11/19/12	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*	Accept	*N900 Cust Item I Customer:		Λ* ·	Setup Start	14.21	
Approvals:	Process Pl	an: MLJ	Date: \2-1\-\5	Tooling:	Ds	ite:	1	Run Star	*NR1*	
	QC:	7.100	Date:	SPC (Y/N):		nte:		Stop	*NR2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp	
Draw Nbr	Re	vision Nbr								
D3912	В									
100		Pick Kit		0.00			- 2		11	
100							6x		13	16
Packaging		Memo		0.00						
Packaging										
110				0.00					100	2-
110				0.00			62	1		1.
Small Fab		Memo		0.00			K		7	13
Small Fab		I-Assemble TRIM RIVE	D3912-1/-3/-5 and install ri TS 1.250" LONG	vets as per dwg				PI	0/	-
		2- Install he	lical, spring plunger and spri	ing pin lanyard assy as	per dwg					1
										1
120		QC5-Inspect part comp	eteness to step on W/O	0.00			,			1
120				:0	-89		6			
QC		Memo		0.00	326					
Quality Control				1.						

NCR (Yes)/	No				WORK ORDER NON-C	O	NFORM	MANCE / UPDAT	E	DQA	Date:	13/02/08
The same	No]	239	161- 12-2	м/		DISPOSITION Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube C Machining S noforming	rosstube mall Fab Finishing omposite	Pro	/PROCESS Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty	Descr	iption of work order update or Non-conformance		nitial lief Eng	Action Descript	on	Sign & Date	Verification	QCInspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		lados	(10	4	to s	Ap 4 Zivets cutted Nort Y (9) C Operato sexure	13	M h16	Replace MS20165-ll	MZO XY	13/02/04	DAS 153 13.0.7	OAS 16 9 052042 131217
A 2 5 16						F	AUL	T CATE	GORY		N. 12		TRA .
Landi	Ce Cra Cru Cu He Ins	nding ntre No acks ushed/0 ffs at Trea pection	Strip in		O/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/Uncle enance	ear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		ples in rque W	Bend aves in E	xtrusio	n	Drill Holes Drawing		Offset Out of (Calibration		2/5	75 05 545	

Out of Sequence

Outside E-imensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Order ID 93161

93161

Page 2

November-15-12 8:56:55 AM

Required Date: 11/30/12

Item ID:

D3912-041

Accept

N900040100

Setup Start

Stop

Item Name: Start Date:

Revision ID:

11/19/12

QC:

Eyebolt Receiver Assembly

Start Qty: 12.00 Req'd Qty: 12.00 *12* *12*

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

5+672

Tooling:

Date: Date:

Tool #

Plan

Code

Run Start

Stop

Reject

Qty

Accept

Qty

Insp. Stamp

Sequence ID/ Work Center ID

170

170 Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ Run Hours

0.00

SPC (Y/N):

0.00

180

QC21- Final Inspection - Work Order Release

0.00

180

OC Quality Control

Memo

Memo

0.00

Reject

Number

W13.02.06

												DQA:	Date	e:	
NCR.	/es	/ No					WORK ORDER NON-C	O	NFORM	MANCE / UPDAT	TE			- 547	
										100		QA Closed:	Date	e:	
Work Orde	er:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	No.						Rework Scrap Use-as-is Work Order Update		Thern	Machining Soften	rosstube Small Fab Finishing omposite		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root		-2	Tex		Desc	1.0	tion of work order update	-	nitial	Action		Sign &			
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Descripti	on	Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			XC												
							F/	4UL	T CATE	GORY		W. W.			
Landi							General		1			10 10 10		31/16	
		Bending Centre No	ot Concer	ntric to	o/s		Bend BOM/Route		Grain Hardwa			Ovalized Over/Under			Pressure/Forced Temperature/Cure
	-	Cracks			-	_	Broken/Damaged Burrs	-	4 8	on Incomplete	715	Part Incorre Part Lost/M			Weld Wrong Stock Pulled
	-	Crushed/0 Cuffs	crimped		-	-	Contamination	-	Mainte	ions Incomplete/Unci	ear	Part Moved	M. X. S. T.		wrong Stock Pulled
Sec.	-	Heat Trea	t		-	-	Countersink		Mislabe			Positioned \			
	-	Inspection		Tube	1		Cut Too Short	-	Misread			Power Loss/			Other
	$\overline{}$	Ripples in					Drill Holes		Offset			1			Tex.
3		Torque W		xtrusio	n		Drawing		Control Control	Calibration			170		

Cut of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

November-15-12 8:56:54 AM

Work Order ID:

93161

Parent Item:

D3912-041

Parent Item Name:

Eyebolt Receiver Assembly

Start Date: 11/19/12

Required Date: 11/30/12

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP RevA: new issue DD 09.11.18 verified by:EC

IPP Rev:B 10.06.10 memo in

seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE TO ENLARGE WASHER

HOLE FOR IT TO FIT*** DD verf.JLM IPP REV:C AS PER REV B 10-08-05 JLM

VERIFIED:DD

	VERIFIED:DD											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Date Issued Issued	Status
NAS1149C0663R Washer		Purchased	No				Each	128.0000		12	J3,	62/66
				Location		Loc Qty	Lo	oc Code		//		1
				ST297		128						
					893	128				6	01	
D3912-1		Manufactured	No			100	Each	8.0000	1	12 /		1.
Eyebolt											13/	02/06
				Location		Loc Qty	Lo	oc Code				200
				ST144		8					388 F	10 (IX)
				77()73	Z				9-	B9371	3(30)
				890	084	6.			0		1	1
D3912-3		Manufactured	No			100	Each	25.0000	2	24	13/	a for
Eyebolt Block											1	0
				Location		Loc Qty	Lo	oc Code		//		
				ST144		25				_//	3937	41600
				865		2 7				2	073	76
				90:		8				_		
				918		8				8	11	, ,
D3912-5		Manufactured	No			100	Each	40.0000	2	24	5/(;	1
Eyebolt Plate		Translation CG								(15/	02/06
				Location		Loc Qty	L	oc Code		/	1	/
				ST144		40:						
					367	1					792-	190
				88-	406	23					第937	16/4
				89.	257	16			-	8		1

											DQA.	Date.	
NCR:	Yes	/ No				WORK ORDER NON-C	On	VFOR	MANCE / UPD	ATE	QA Closed:	Date:	
	_				IXX.							4 7 197	7
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part I	Vo.					Scrap			Machining	Small Fab	-	l. Eng. Coor.	Quality
NCR	VI.O.					Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
MCK	VO.					Work Order opdate	1		Large Fab	Composite		Supplier[l ES
Root	41				Descri	ption of work order update	1	nitial	Actio	on	Sign &		Series - P. J.
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descrip	ption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	\vdash										3.3		
Operator	-									1			=
Material	Н										1 4 4		
Setup Other	H									3	16/6		
Process	-												
Supplier	Н									7			
Training	Н										3 4 6 6 4		
Unapproved	-										15		
/2						F/	AUL	T CATE	GORY		11 12 No. 1		
Landi	ng G	Gear				General				_	3,01		
		Bending				Bend		Grain			Ovalized	Kirkore 2 P. Walte	Pressure/Forced
		Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa	re	- 2	Over/Under		Temperature/Cure
	-	Cracks				Broken/Damaged	1	1 0	ion Incomplete		Part Incorrec	SABI DESIGNATION OF THE PARTY O	Weld
	-	Crushed/	Crimped			Burrs		1	ions Incomplete/Ur	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	-	Cuffs				Contamination		Mainte			Part Moved		
in.	\vdash	Heat Trea				Countersink		Mislabe		j 20	Positioned V	AND THE RESERVE AND THE PERSON NAMED IN COLUMN TWO IS NOT THE PERSON NAMED IN COLUMN TO THE PERS	1
765-	$\overline{}$	Inspection		Tube		Cut Too Short	_	Misread	i		Power Loss/	Surge	Other
100		Ripples in	Bend			Drill Holes		Offset					

Out of Calipration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Heli-Coil

Required Date: 11/30/12

Required Oty: 12.00

November-15-12 8:56:54 AM

Work Order ID: 93161 D3912-041 Start Date: 11/19/12 Parent Item: Evebolt Receiver Assembly Start Oty: 12.00 Parent Item Name: D3801-1 Fach 13.0000 Manufactured Hand Retractable Spring Plunger Loc Qty Loc Code Location 13 ST066 11 75178 82615 2 10t) Each 364.0000 MS20615-4M20 No Purchased RIVET Location Loc Qtv Loc Code GA 364 119546 26 120644 7 9 121339 32 121463 90 122416 200 122807 MS21209-F615 Purchased No Each 40.0000

Location

121561

ST304

12 JS 13 /02/06

Lec Oty

40

40

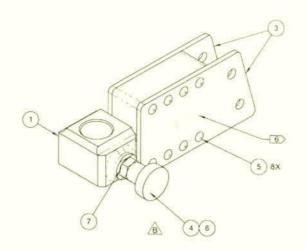
Loc Code

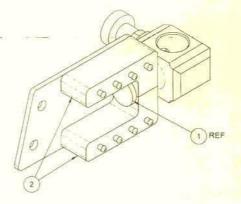
		DQA: Date:	
ICR Ves / No	WORK ORDER NON-CONFORMANCE / UPDA	F	

											QA Closed:	Date	2:		+15
Work Orde	r:		. Inter		DISPOSITION				4	AGAINST DE	PARTMENT	PROCESS			
Part N NCR N	0.				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	S	rosstube small Fab Finishing omposite	37.7.20	Water Jet d. Eng. Coor. e/Packaging Supplier	Er	Quality Other	
Root					ption of work order update		itial		tion		Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	riptic	on	Date	Verification		QC Inspector	
Doc/Data									7		17				
Equip/Tooling									===			a de la companya de			
Operator											49.60	ay .			
Material															
Setup		1									The second		6		
Other						E					100	The last			
Process Process	_														
Supplier												The second second			
Training	-					ļ					in a				
Unapproved		l.			E	AL II T	CATE	GORV	-		1 1988	ALCOHOLD DISTRICTOR		76	0.113
Landin	a Goor				General	MULI	CAIL	GORT			1	MA WENT TO THE TOTAL THE TOTAL TO THE TOTAL TOTAL TO THE	12.1		
Lanuin	Bending				Bend		Grain			10	Ovalized		Pre	ssure/Forced	
	Centre N	nt Conce	ntric to	0/5	BOM/Route		Hardwa	re		1 100	Over/Under	tolerance	100	mperature/Cur	e
4	Cracks	or conicc.	Terror to	-	Broken/Damaged			ion Incomplete		16.	Part Incorre	EV. A DSUE N	We		
	Crushed/	Crimped			Burrs	-		iors Incomplete/	Unce	ear	Part Lost/M	A Vertical Control	200	ong Stock Pulle	ed
	Cuffs				Contamination			enance			Part Moved				
	Heat Trea	at			Countersink		Mislabe				Positioned V	Vrong			
ŧ.	Inspectio		Tube		Cut Too Short		Visread	d	1		Power Loss/		Oth	ner	
	Ripples in				Drill Holes		Offset				1 31		AT TO	達	
	Torque V		xtrusio	n	Drawing		Out of (Calibration			IFE IN				
	Turning S				Finish		Out of S	Secuence			150	5201			
Eng.	Wave/Tv	ist in Tul	oe		Folio		Outside	Dimensions					de,		

ITEM	QTY -041	P/N	DESCRIPTION	
	X	D3912-041	EYEBOLT RECEIVER ASSY	
1	1	D3912-1	EYEBOLT	3
2	2	D3912-3	EYEBOLT BLOCK	
3	2	D3912-5	EYEBOLT PLATE	
4	1	D3801-1	SPRING PLUNGER	
5	8	MS20615-4M20	RIVET	
6	1	MS21209-F615	HELICAL	
7	1	NAS1149F0332P	WASHER	



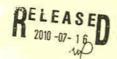




SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

UNLONG TO BE THE COMY

93161 MLJ



D3912-041 EYEBOLT RECEIVER ASSY

NOTES: 1) MATERIAL: N/A

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -041: 1.58 lbs

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; M521209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0863R ADDED; BOSS ADDED TO D3912-1. В 10.06.28 NEW ISSUE A 10.03.04 REV DESCRIPTION DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3912 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE EYEBOLT RECEIVER ASSY DE APPR NTS COPYRIGHT @ 2010 BY DART AEROSPACE LTD DATE 10.06.28

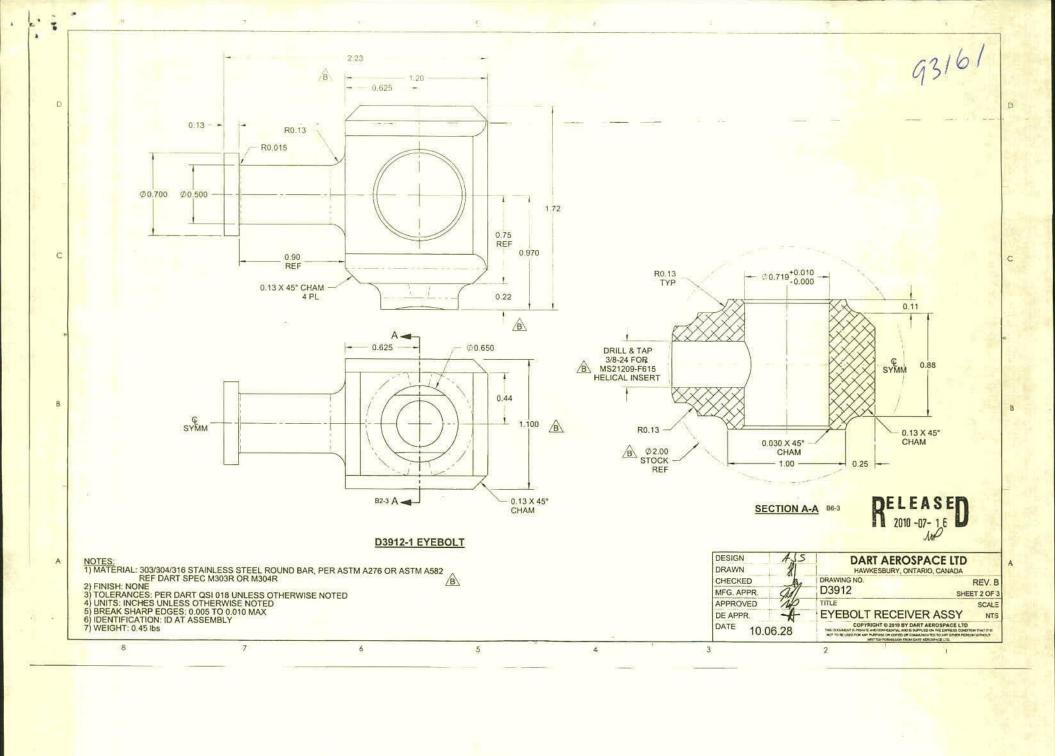
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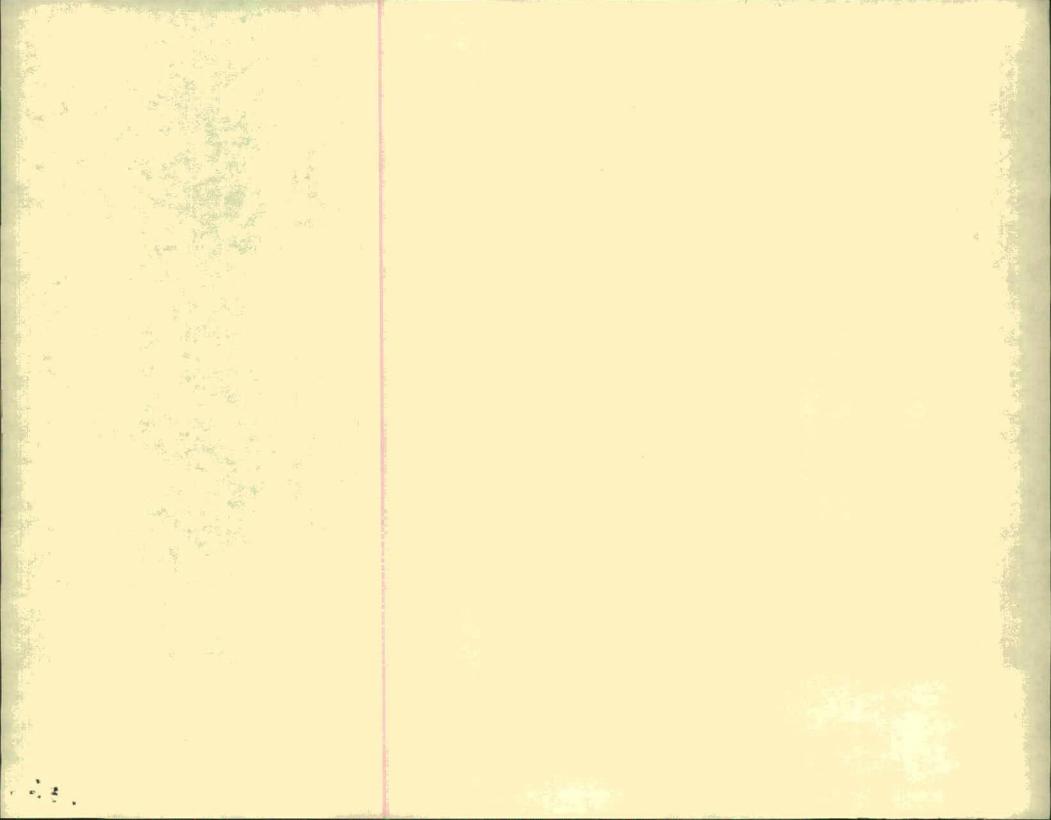
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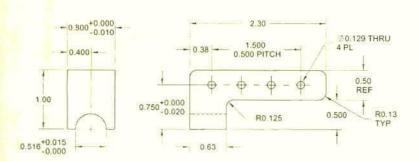
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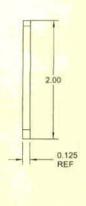






D3912-3 EYEBOLT BLOCK

3,15 1.500 10.375 R0.13 0.500 PITCH TYP - C 38 0.25 - 0 0.517 1.000 1.500+0.020 105° REF Ø0.129 \$0.257 8 PL 2 PL 3.65 3.69 REF



D3912-5 EYEBOLT PLATE

Ant

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

8

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3, 0.30 lbs

-5 0.24 lbs

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3912 MFG. APPR SHEET 3 OF 3 TITLE APPROVED SCALE EYEBOLT RECEIVER ASSY DE APPR COPYRIGHT © 2016 BY DART AEROSPACE LTD
TO PRIVATE AND COMERNIN, AND IS SUPPLIED ON THE DEPTHS CONDICTOR TO MAY PURPOSE OF COMERNICATED TO MAY RETIRED FROM DATE 10.06.28

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